

Date: Friday, 09/05/2008 1:47:06 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LH STEP ACTUATOR ASSEMBLY		
Job Number	: 39167		Part Number	: 41232 000 001 001		
Estimate Number	: 12758		Drawing Number	: 41232-000-001 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 09/05/2008		Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 30/05/2008		
Previous Run	: 35059		Qty:	2		
Written By	:		Um:	Each		
Checked & Approved By	<u>JUL 08.5.09</u>					
Comment	: Est Rev:A New Issue 07-02-28 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		JLD 08.5.13	
		Comment: DOCUMENT CONTROL D205-763	
		Photocopy bluefile & type labels per PPP41232-000-001	CHG 002
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1	
		Pick Packing Kit	
3.0	AP0925ELBN	BARBED ELBOW	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		BARBED ELBOW	
		Batch: M103727	
4.0	AN960JD416	Washer	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Washer	
		Batch: M107321	
5.0	MS21042L4	Nut	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Nut	
		Batch: M106051	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 AN423A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M103688

AS 08/05/15 (X2)

7.0 MS3548993 GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GROMMET

Batch: M106168

AS 08/05/15 (X2)

8.0 AN960JD416L Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

M107008

AS 08/05/15 (X2)

9.0 MS24665151 Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cotter Pin

M14526

AS 08/05/15 (X2)

10.0 MS203923C21 Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

M104156

AS 08/05/15 (X2)

11.0 R 3400 plastic tubing 1/4id x 3/8od-black



Comment: Qty.: 3.0500 f(s)/Unit Total : 6.1000 f(s)

plastic tubing 1/4id x 3/8od-black

Cut to 18" Long X2

Batch: M104229

Comp Satisfied
New B&T & Batch
NO Qty.

AS 08/05/15 (X2)

12.0 41232 200 006 001 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

30585

AS 08/05/15 (X2)

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Job Number:



Seq. #:	Machine Or Operation:	Description :
13.0	41232 200 005 001	Spacer (Step Actuator)
	Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s) Spacer (Step Actuator) Batch: 30503	AS 08/05/15 (x2)
14.0	41232 200 004 001	Reducer Tee Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Reducer Tee Assembly Batch: 31779	AS 08/05/15 (x2)
15.0	41232 200 003 001	Spring (Step Actuator)
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Spring (Step Actuator) Batch: 30941	AS 08/05/15 (x2)
16.0	41232 200 001 001	Step Actuator LH Ass'y
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Step Actuator LH Batch: B39174	AS 08/09/23 (x2)
17.0	124K002 4CR 0545	Hose ass'y-Step Actuator
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Hose ass'y-Step Actuator BATCH: M104042	AS 08/05/15 (x2)
18.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
	Comment: INSPECT 100% KITS FOR COMPLETENESS	AS 08/09/23 (x2)
19.0	PACKAGING.1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP 41232-000-001-001 Location: _____ PPP Rev: _____ Rev B	AS 08/09/23 (x2)

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Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/23
JL

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-23

W/O:		WORK ORDER CHANGES					
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REVISION					
LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	1/14/04	INCORP. E.O.; CHG. P/N OF ITEM #17. MINOR CHANGE - FAR 21.95	1504-1-1	1/14/04

A

1	1	17	PS4025E000DF540A	HOSE				
1	1	16	AP0925ELBN	BARBED ELBOW	ARK-PLAS PRODUCTS, INC., FLIPPIN, ARKANSAS 72634			
2	2	15	AN960JD416	WASHER				
1	1	14	MS21042-L4	NUT				
1	1	13	AN4-23A	BOLT				
AR	AR	12	MIL-S-8802	SEALANT				
1	1	11	MS35489-93	GROMMET				
2	2	10	AN960JD416L	WASHER				
1	1	9	MS24665-151	COTTER PIN				
1	1	8	MS20392-3C21	PIN				
2	2	7	R-3400 1/4 ID x 3/8 OD BLACK	PLASTIC TUBING	NORTON PERFORMANCE PLASTICS CORP., AKRON, OHIO 44309			
1	1	6	41232-200-006-001	BRACKET	(ALT. P/N 412-050-026-101, BELL HELICOPTER)			
3	3	5	41232-200-005-001	SPACER				
1	1	4	41232-200-004-001	REDUCER TEE				
1	1	3	41232-200-003-001	SPRING				
1		2	41232-200-001-002	R/H ACTUATOR ASSY				
1	1		41232-200-001-001	L/H ACTUATOR ASSY				
			-002	R/H INSTALLATION				
			-001	L/H INSTALLATION				
-002	-001	FND NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE
102	101			LIST OF MATERIAL				

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41232-1000

NEXT ASSEMBLY

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QUANTITY		DESCRIPTION		LIST OF MATERIAL		TITLE	
1	1			UNLESS OTHERWISE SPECIFIED	DRAFTSMAN D. NELSON	5/20/02	STEP ACTUATOR
				X±.1	CHECK D. MURPHY	5/20/02	INSTALLATION
				XXL±.03			
				XXOL±.010			
		41232-1000		ANGLES ±.1/2"	PROL EMOR		SCALE NONE
				HEAT TREAT			Dwg. No. 41232-000-001
				FINISH	Era Actuator, Inc.		SHT 1 OF 2
							REV. A
QUANTITY		DESCRIPTION		LIST OF MATERIAL		TITLE	
1		NEXT ASSEMBLY		DRAFTSMAN D. NELSON		STEP ACTUATOR	
				CHECK D. MURPHY		INSTALLATION	

SHUP COPY
RETURN TO
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INCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31467

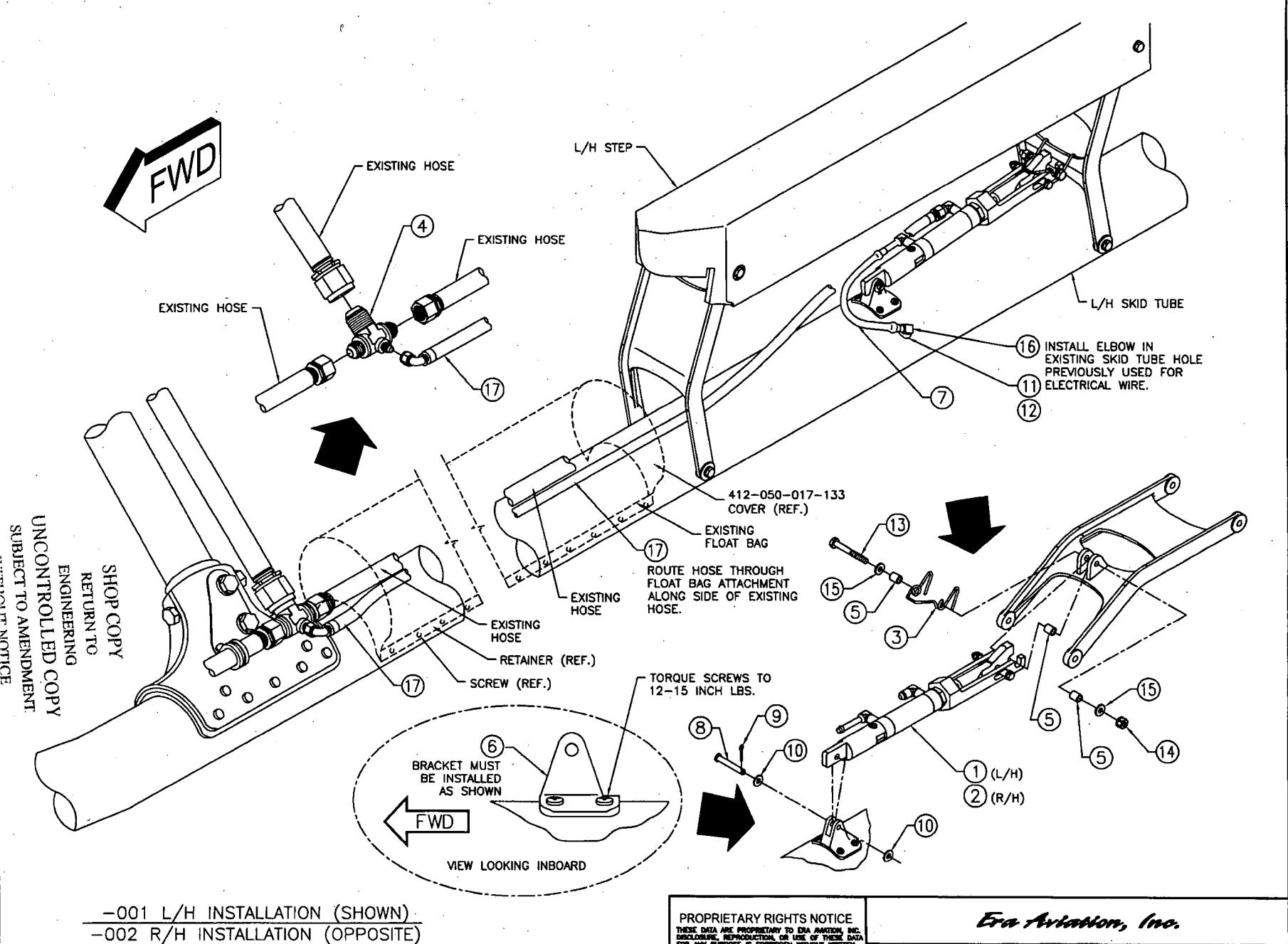
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WORK ORDER
NO. 35167
WITHOUT NOTICE



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ERA Aviation, Inc.

STEP ACTUATOR INSTALLATION

41232-000-001
SHT 2 OF 2

C

DRA. NO.

REV.

A

W/O:		WORK ORDER CHANGES					
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